

Date: Wednesday, 3/7/2007 3:52:58 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	CHAFING SHIELD		
Job Number	31071					
Estimate Number	11138					
P.O. Number	N/A		Part Number	D31901		
This Issue	3/7/2007	S.O. No.	N/A	Drawing Number	D3190 REV A	
Prsht Rev.	NC		Project Number	N/A		
First Issue	N/A		Drawing Revision	A		
Previous Run	28998		Material	N/A		
Written By			Due Date	3/30/2007 Qty: 12 Um: Each		
Checked & Approved By	<u>J.07.03.07</u>					
Comment	Est. A 03/05/26 New issue KJ/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S25GA	304/316 .020" Sheet 	
		Comment: Qty.: 0.2261 sf(s)/Unit Total : 2.7128 sf(s) 304/316 SS .020" Sheet X Material: AISI 304/316 SS 0.020" thick sheet (M304S25GA) Batch: <u>1103678x2</u> FF 07-04-09 12	
2.0	SHEAR	SHEAR 	
		Comment: SHEAR Cut blank: 9.25" x 3.13" Grind corner as per Dwg D3190 Deburr Roll as per Dwg D3190 FF 07-05-03 12	
3.0	QC5	INSPECT WORK TO CURRENT STEP 	
		Comment: INSPECT WORK TO CURRENT STEP SB 07/05/03 12	
4.0	PACKAGING 1	PACKAGING RESOURCE #1 	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>07/05/03 12</u>	
5.0	QC21	FINAL INSPECTION/W/O RELEASE 	
		Comment: FINAL INSPECTION/W/O RELEASE <u>07/05/04</u>	
Job Completion			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/05/04
 QA: N/C Closed: _____ Date: _____

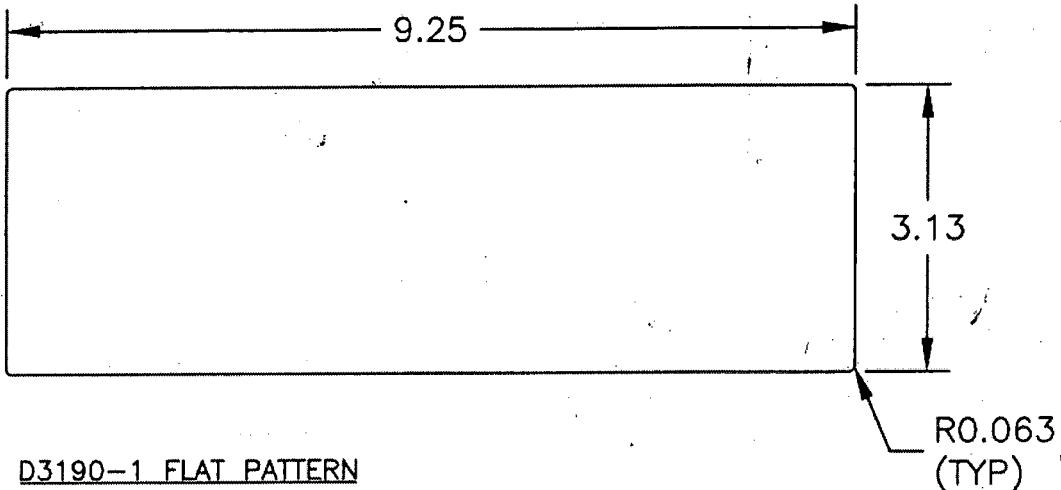
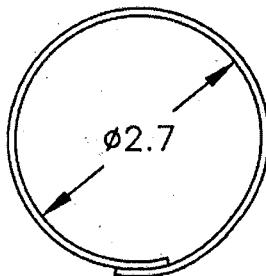
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries.

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3190	SHEET 1 OF 1
DATE	TITLE		SCALE
03.05.16	CHAFING SHIELD		1:2
A	03.05.16	NEW ISSUE	

RELEASED
03.05.22

D3190-1 FLAT PATTERND3190-1 ROLLING DETAIL
NOT TO SCALED3190-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31091

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2

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